



Dart Hawkesbury
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

D2435
Job Sheet 167661



FOR STC
[Signature]

Part No: D2435

Job Qty: 1 ea *14*

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/5/17

Job Tracking No:

Due Date: 11/14/17

Created By: Linda Lacelle

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/13/17	11/13/17	0.00	0.00	Start up container		<i>De</i>
120	Waterjet	10 pcs	11/13/17	11/13/17	0.00	1.86	Waterjet1		<i>De</i>
130	CNC Vertical Machining	10 pcs	11/14/17	11/14/17	0.41	10.14	HAAS 1		<i>mark SL</i>
150	QC	10 pcs	11/14/17	11/14/17	0.00	0.00	QC8		<i>11/17/17</i>
151	Packaging	10 pcs	11/14/17	11/14/17	0.00	0.00	Packaging3		<i>11/17/17</i>
190	QC21-SA	10 Ea	11/14/17	11/14/17	0.00	0.00	QC21		<i>11/17/17</i>

Part Op 120 - CUT BLANK AS PER FILE D2435

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435

NOV 23 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10	32	1,232	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.063Inches + 0.030 - 0.010	0.093 0.053		
2	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	Angle	
3	Bearpaw	5.500Inches ± 0.030	5.530 5.470		
4	Bearpaw	0.200Inches ± 0.030	0.230 0.170		
5	Bearpaw	0.250Inches ± 0.010	0.260 0.240	Radius	
6	Bearpaw	0.250Inches ± 0.030	0.280 0.220		
7	Bearpaw	0.625Inches ± 0.030	0.655 0.595		
8	Bearpaw	0.250Inches ± 0.010	0.260 0.240		
9	Bearpaw	45.000Degrees ± 0.000	45.000 45.000	Angle	
10	Bearpaw	0.375Inches ± 0.010	0.385		

PART NO:
Revision:
Operation:
Change No:

Start up Operation

D2435

Bearpaw



DART
AEROSPACE
S008869

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Mfg Date: 11/10/17
Job No: 167661

			0.365	
11	Bearpaw	19.000Inches ± 0.030	19.030 18.970	
12	Bearpaw	0.950Inches $+ 0.030$ $- 0.010$	0.980 0.940	
13	Bearpaw	0.260Inches $+ 0.005$ $- 0.000$	0.265 0.260	Diameter
14	Bearpaw	0.930Inches ± 0.030	0.960 0.900	Diameter
15	Bearpaw	0.300Inches $+ 0.030$ $- 0.000$	0.330 0.300	
16	Bearpaw	0.375Inches ± 0.030	0.405 0.345	
17	Bearpaw	7.375Inches ± 0.030	7.405 7.345	
18	Bearpaw	4.250Inches ± 0.010	4.260 4.240	
19	Bearpaw	2.000Inches ± 0.030	2.030 1.970	
20	Bearpaw	9.000Inches ± 0.010	9.010 8.990	
21	Bearpaw	15.750Inches ± 0.030	15.780 15.720	

Plex 11/5/17 1:38 PM dart.lacelle.linda

DART AEROSPACE LTD		Work Order:	167661
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.060 x 45°	/		vern	mm L-05
B 5.500	+/-0.030	5.501	/		↓	
C 0.200	+/-0.030	0.195	/		↓	
D R0.250	+/-0.030	0.250	/		RG	
E 0.250	+/-0.010	0.241	/		vern	mm L-05
F 0.625	+/-0.030	0.622	/		↓	
G 0.25 x 45°	+/-0.030	0.250 x 45°	/		↓	
H 0.375	+/-0.010	0.377	/		↓	
I 19.000	+/-0.030	19.00	/		tape	
J 0.950	+0.030/-0.010	0.940	/		vern	mm L-05
K Ø0.260	+0.005/-0.000	0.260	/		↓	
L Ø0.930	+/-0.030	0.930	/		↓	
M 0.30	+0.030/-0.000	0.310	/		↓	
N 0.375	+/-0.030	0.378	/		↓	
O 7.375	+/-0.030	7.370	/		vern 12"	CVC-02
P 4.250	+/-0.010	4.250	/		vern	mm L-05
Q 2.000	+/-0.030	2.00	/		↓	
R 9.000	+/-0.010	9.00	/		tape	
S 15.750	+/-0.030	15.750	/		tape	

Measured by: <i>mm L</i>	Audited by: <i>33</i>	Prototype Approval:	N/A
Date: 17/11/20	Date: 17/11/22	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF <i>RF</i>	<i>RF</i>